

Date: Friday, 29/09/2006 9:12:38 AM  
 User: Linda Lacelle

## Process Sheet

*split 206.10.13*

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number : 28779 -1	
Estimate Number : 10531	
P.O. Number : <i>NIA</i>	Part Number : D2572
This Issue : 29/09/2006 S.O. No. : <i>NIA</i>	Drawing Number : D2572 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>NIA</i>	Drawing Revision : E
Previous Run : 28445	Material : <i>NIA</i>
Written By : _____	Due Date : 06/10/2006
Checked & Approved By : <i>W</i>	Qty: <i>6</i> Um: Each
Comment : Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101005	7075-T7351 8.25X5.0X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 7075-T7351 8.25X5.0X2.5  
 Make from D6101-005 billet for D2572  
 Ensure that grain is along 5.00" length  
 Batch No: *B25351*

*J.G**06/09/29*

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
 Program Batch No. *28779* Double check by: *J.F.*

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets  
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets  
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets  
 4-Deburr and remove all machining marks  
 5-Tumble to remove sharp edges.

*ml 06/10/02*

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE  
 Machine keyway as per dwg D2571 & D2572

*ml 06/10/02*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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Job Number:



Seq. #:	Machine Or Operation:	Description :
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4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*En 06/10/02*

*split  
PTO*

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*En 06/10/13*

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*u.a. 06/10/13*

*(6)*

7.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*M101575*

*yk 06/10/13an x (6)*

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT

*Py 4/10/10 (6)*

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*57479*

*Py 4/10/10 (6)*

10.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

*Py 06/10/10 (6)*

Job Completion



*C 206110114*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-10-13	4.0	W/O split due to NCR: waiting for eng. approval. split - 1: 6 saddles on this W/O remain. - 2: 1 saddle.	<i>[Signature]</i>	06-10-13	6	<i>[Signature]</i>	<i>[Signature]</i> 06-10-13

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: *[Signature]* Date: 06/10/16  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



90. 2. 50

MATERIAL: 7075-T7351 (90-A-250/12)  
(REF PART SPEC. D8102-003)  
ACID ETCH, ALODINE PER PART QSI 005 4.1  
FINISH:  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
PART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER PART QSI 0.01A UNLESS OTHERWISE NOTED

ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010

CHAMFER 0.063" x 45° AROUND THIS SURFACE  
(TYPICAL 2 PLACES)

CHAMFER 0.063 x 45° ALL AROUND

CHAMFER 0.033 x 45° (SEE DETAIL C)

VIEW B-B

DETAIL C  
SCALE 2:1

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCRP. DEC 9123/9079/9102
		ADD DIMENSIONS PER TSR A1177
B	95.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

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<b>DART</b>	DRAWING NO.	REV.	
	D2572	SHEET 1 OF	SCALE
TITLE			
INNER FWD SADDLE			

**REFERENCE ONLY**

БЕЛОРУССКАЯ СЛОВАРЬ



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	29729
<b>Description:</b> Saddle, Fwd Inboard	<b>Part Number:</b>	D2572
<b>Inspection Dwg:</b> D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	<del>DT8682</del>	0.440	0.439	0.439	0.439		
B	1.745	1.755		1.750	1.749	1.750	1.749		
C	3.495	3.505		3.506	3.499	3.506	3.499		
D	1.745	1.755		1.750	1.749	1.750	1.749		
E	7.990	8.010		7.995	7.999	7.999	7.999		
F	0.490	0.510		0.501	0.499	0.501	0.502		
G	0.257	0.262	<del>DT8683</del>	0.258	0.258	0.258	0.258		
H	0.375	0.380	<del>DT8684</del>	0.377	0.376	0.376	0.377		
I	0.490	0.510		0.500	0.498	0.500	0.498		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	0.568	0.567	0.566		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.494	1.495	1.495	1.495		
N	2.495	2.505		2.499	2.499	2.499	2.499		
O	3.869	3.879		3.873	3.873	3.872	3.873		
P	0.115	0.135		0.124	0.125	0.124	0.124		
Q	0.115	0.135		0.133	0.135	0.135	0.135		
R	0.240	0.260		0.253	0.253	0.253	0.254		
S	0.115	0.135		0.121	0.124	0.125	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.961	2.960		
V	0.230	0.250		0.241	0.238	0.239	0.241		
W	0.115	0.135		0.116	0.125	0.124	0.124		
X	0.307	0.312		0.309	0.309	0.310	0.308		
Y	0.760	0.765		0.766	0.766	0.766	0.766		
Z	0.352	0.372		0.367	0.369	0.365	0.369		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.628	0.628	0.630		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.247	0.249	0.252		
AE	1.375	1.395		1.384	1.381	1.382	1.380		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.240	0.240	0.240	0.240		
AH	0.240	0.260		0.252	0.250	0.252	0.253		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.035	0.035	0.035	0.035		
Accept/Reject									

Measured by:	mf
Date:	06/10/02

Audited by:	EP
Date:	06/10/13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	





<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 28779
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K	0.558	0.578		0.567	0.566				
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M	1.490	1.500		1.500	1.500				
N	2.495	2.505		2.500	2.500				
O	3.869	3.879		3.872	3.872				
P	0.115	0.135		0.124	0.123				
Q	0.115	0.135		0.135	0.135				
R	0.240	0.260		0.253	0.253				
S	0.115	0.135		0.127	0.124				
T	0.178	0.198		0.188	0.188				
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V	0.230	0.250		0.241	0.240				
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AA	0.470	0.530		0.500	0.500				
AB	0.615	0.635		0.629	0.629				
AC	0.053	0.073		0.063	0.063				
AD	0.240	0.260		0.251	0.247				
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AF	0.115	0.135		0.135	0.135				
AG	0.240	0.280		0.241	0.240				
AH	0.240	0.260		0.253	0.253				
AI	2.000	2.020		2.000	2.000				
AJ	0.023	0.043		0.035	0.035				
Accept/Reject									

Measured by:	mf
Date:	06/10/102

Audited by:	En
Date:	06/10/13

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A		New Issue	RF	
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